



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571

Job Sheet 172059



Part No: D2571

Job Qty: 12 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/16/18	2/16/18	0.00	0.00	Start Up Machining		
100	CNC Vertical Machining	12 pcs	2/17/18	2/17/18	0.57	19.35	HAAS 1		
110	Mill Conv	12 pcs	2/17/18	2/17/18	0.00	1.85	Mill Conv 1		
120	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC2		
130	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC8		
140	HandFinish	12 pcs	2/17/18	2/17/18	0.00	0.40	HandFinish1		
150	Powdercoat	12 pcs	2/19/18	2/19/18	0.00	0.48	Powdercoat1		
160	QC	12 pcs	2/19/18	2/19/18	0.00	0.00	QC3		
170	Packaging	12 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3		
180	QC21-SA	12 Ea	2/19/18	2/19/18	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per
Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and inspect
110 - Machine keyway as per dwg D2571 & D2572
120 - Inspect on CMM as per folio CMMA022.
150 - START TIME: 1:00pm FINISH TIME: 1:30pm 320°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	12	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		

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Container No: S045111



Part: D2571

Job No: 172059

Serial No/Batch: S045111

Revision: D2571

Inspector:

Date: 02/25/18

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

5	Saddle, Fwd Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Outboard	0.257Inches + 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches + 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches + 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches + 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches + 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches + 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches + 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches + 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches + 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches + 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches + 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches + 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches + 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches + 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches + 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches + 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches + 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches + 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches + 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches + 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches + 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Outboard	0.023Inches + 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD	Work Order: 172 059
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		438	438	438	438	VJH	18/03/01
B	1.745	1.755		1750	1750	1750	1750		
C	3.495	3.505		3,500	3,500	3,500	3,500		
D	1.745	1.755		1750	1750	1750	1750		
E	7.990	8.010		7999	8,000	7,999	8,000		
F	0.490	0.510		498	500	500	500		
G	0.257	0.262		257	257	257	257		
H	0.375	0.380		375	375	375	375		
I	0.490	0.510		500	500	500	500		
J	1.174	1.184		1179	1179	1179	1179		
K	0.558	0.578		568	568	568	568		
L	1.174	1.184		1179	1179	1179	1179		
M	1.490	1.500		1,495	1,495	1,495	1,495		
N	2.495	2.505		2,500	2,500	2,500	2,500		
O	3.869	3.879		3,874	3,874	3,874	3,874		
P	0.115	0.135		130	130	133	130		
Q	0.115	0.135		125	125	125	126		
R	0.240	0.260		253	253	253	254		
S	0.115	0.135		125	127	125	126		
T	0.178	0.198		188	188	188	188		
U	2.940	2.980		2,960	2,960	2,960	2,960		
V	0.230	0.250		242	241	241	239		
W	0.115	0.135		130	122	125	121		
X	0.306	0.313		311	311	311	311		
Y	0.750	0.760		760	760	760	760		
Z	0.352	0.372		363	363	363	363		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		625	625	625	625		
AC	0.063	0.073		063	067	063	065		
AD	0.240	0.260		254	251	251	249		
AE	1.385	1.395		1385	1385	1385	1385		
AF	0.115	0.135		125	128	126	128		
AG	0.240	0.260		245	245	245	252		
AH	0.240	0.260		254	252	250	250		
AI	2.000	2.020		2,000	2,000	2,000	2,000		
AJ	0.033	0.048		033	033	033	0,033		

Accept/Reject

Measured by: SBL	Added by:
Date: 18/02/27	Date:

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 172 059
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 4

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	#7	#8		
A	0.438	0.443		.438	.438	.438	.438	VHJ	18/03/11
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.499	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.500	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.568	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.495	1.505		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.874	3.879		3.874	3.874	3.875	3.875		
P	0.130	0.135		.130	.128	.132	.126		
Q	0.125	0.130		.125	.125	.125	.125		
R	0.240	0.260		.253	.252	.253	.253		
S	0.120	0.130		.126	.125	.126	.126		
T	0.178	0.188		.188	.188	.188	.188		
U	2.960	2.970		2.960	2.960	2.960	2.960		
V	0.240	0.250		.240	.240	.240	.240		
W	0.121	0.126		.121	.122	.121	.121		
X	0.311	0.316		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.364	0.374		.364	.363	.363	.364		
AA	0.470	0.480		.500	.500	.500	.500		
AB	0.625	0.635		.625	.625	.625	.625		
AC	0.060	0.070		.060	.060	.062	.066		
AD	0.252	0.262		.252	.252	.250	.250		
AE	1.385	1.395		1.385	1.385	1.385	1.385		
AF	0.128	0.138		.128	.128	.130	.132		
AG	0.250	0.260		.250	.252	.248	.255		
AH	0.250	0.260		.250	.250	.250	.250		
AI	2.000	2.010		2.000	2.000	2.000	2.000		
AJ	0.033	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SBZ	Added by:
Date: 18/02/28	Date:

Rev	Date	Change	Revised by	Approved
B	01/09/24	Re-format; Added Rev. D	KJ	
C	01/01/11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	01/05/08	Added dimension AI	KJ/KF	
E	01/12/05	Added dimension AJ	KJ/JLM	
F	10/02/07	Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 172 059	
Description: Saddle Fwd Outboard		Part Number: D2571	
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. F and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.431	0.435		0.438	0.439	0.438	0.438	N/A	18/03/11
B	1.745	1.755		1.750	1.749	1.749	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.740	1.750		1.7500	1.749	1.749	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.500	0.510		0.500	0.505	0.504	0.500		
G	0.250	0.270		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.500	0.510		0.500	0.500	0.500	0.501		
J	1.175	1.185		1.179	1.179	1.179	1.179		
K	0.565	0.575		0.567	0.568	0.568	0.568		
L	1.175	1.185		1.179	1.179	1.179	1.179		
M	1.495	1.505		1.495	1.495	1.495	1.495		
N	2.500	2.510		2.500	2.500	2.500	2.500		
O	3.874	3.884		3.874	3.874	3.874	3.874		
P	0.125	0.130		0.125	0.130	0.130	0.129		
Q	0.125	0.130		0.125	0.126	0.125	0.125		
R	0.250	0.260		0.253	0.253	0.253	0.253		
S	0.125	0.130		0.127	0.126	0.125	0.131		
T	0.188	0.192		0.188	0.188	0.188	0.188		
U	2.960	2.970		2.960	2.960	2.960	2.960		
V	0.240	0.245		0.241	0.240	0.240	0.241		
W	0.121	0.123		0.121	0.123	0.121	0.121		
X	0.311	0.312		0.311	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.362	0.363		0.364	0.363	0.362	0.363		
AA	0.500	0.510		0.500	0.500	0.500	0.500		
AB	0.625	0.627		0.625	0.627	0.628	0.629		
AC	0.062	0.065		0.072	0.060	0.062	0.062		
AD	0.250	0.255		0.252	0.251	0.250	0.250		
AE	1.385	1.385		1.385	1.385	1.385	1.385		
AF	0.123	0.130		0.123	0.130	0.128	0.128		
AG	0.250	0.252		0.250	0.252	0.250	0.250		
AH	0.250	0.250		0.252	0.250	0.249	0.250		
AI	2.000	2.000		2.000	2.000	2.000	2.000		
AJ	0.033	0.033		0.033	0.033	0.033	0.033		

Accepted by:

Measured by: SBL
Date: 18/02/08

Edited by:
Date:

Rev	Date	Change	Revised by	Approved
01	09.03	e-format; Added Rev. D	KJ	
02	01.11	e-format; Added DT8682, DT8683, DT8684	KJ	
03	05.05	added dimension AJ	KJ/RF	
04	12.06	added dimension AJ	KJ/JLM	
05	13.07	Rev updated	KJ	